

Work Order ID 80259-1

80259

Page 1

February-15-12 3:34:19 PM

Item ID: D3560-041

Revision ID:

Item Name: Arm Weldment

Start Date: 15/02/2012 Start Qty: 10.00

Required Date: 29/02/2012 Req'd Qty: 10.00

Reference:

Approvals: Process Plan: *H.L.J*

QC:

Date: 12/02/16

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Setup Start *NS1*

Stop *NS2*

Run Start *NR1*

Stop *NR2*

Cust Item ID:

Customer:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3560

Rev D

0.00

100

BAND SAW

0.00

100

Bandsaw

Memo

Jeaspa Bandsaw

Cut blanks 16.750" long

0.00

110

HAAS CNC VERTICAL MACHINING #1

0.00

110

HAAS 1

HAAS CNC vertical machine #1

Memo

1- Mill as per Folio FA693 Rev: *AK* & Dwg D3560 Rev: *D*

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

0.00

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Quality Control

Memo

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3560-041

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Arm Weldment

Start Date: 15/02/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 29/02/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Run Start ***NR1***

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

12/03/16

10

0

130

QC

Memo

0.00

Quality Control

140

Large Fab

0.00

1 0

12.04.30

140

Large Fab

Large Fab

Memo

0.00

1-Weld assembly as per dwg D3560

STEP:

1- clean material (buff bracket and bottom of arm with blue pad)

2- set up bracket and arm on jig

3- preheat bracket and arm with torch

4- clean before welding with brush

5- set up machine to 135 amps

6- weld across bottom and top ends

7- reheat with torch (65 deg C)

8- on one side weld from bottom to top half way

9- same for other side (half way)

10- from half way point weld the rest of the first side (ease off pedal near end)

11- same for remaining side (ease off pedal near end)

Alum. Rod # 120854

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Page 3

Item ID: D3560-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Arm Weldment

Start Date: 15/02/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 29/02/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

150

0.00

QC

Memo

Quality Control

160

QC9- Inspect visual per QSI004- Fusion Welds

0.00

160

0.00

QC

Memo

Quality Control

170

Chemical Conversion Coat per QSI005 4.1

0.00

170

0.00

HandFinish

Memo

Hand Finishing

Schedule

H

241

1 0 BE 12/04/30

① 751245-1

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Item ID: D3560-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Arm Weldment

Start Date: 15/02/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 29/02/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC3- Inspect Part Finish

0.00

180

QC

Memo

0.00

Quality Control

1x

0

12/05/01

190

Small Fab

0.00

190

Small Fab

Memo

0.00

Small Fab

1-Press bushing in D3560 arm per dwg D3562

1x

0

12/05/01

200

QC5- Inspect part completeness to step on W/O

0.00

200

QC

Memo

0.00

Quality Control

1x

0

12/05/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80259

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Page 5

Item ID: D3560-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Arm Weldment

Start Date: 15/02/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 29/02/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Run Start

NR1

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

Identify as per dwg & Stock Location: *WA*

0.00

210

Packaging

Memo

0.00

Packaging

*** STOCK IN STEP CELL***

1

12.05.01

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

12/5/1
MF
12-05-01

Picklist Print

February-15-12 3:34:23 PM

Page 1

Work Order ID: 80259

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Parent Item: D3560-041

D3560-041

Parent Item Name: Arm Weldment

Start Date: 15/02/2012

Required Date: 29/02/2012

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev:A New Issue 07.05.24 EC
 IPP rev B ECN 987 07.10.09 EC verified by: DD
 IPP Rev:C ECN1048 07-12-18 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2808

Manufactured

No

100

Each

70.0000

1

10

**

D2808

Bushing

Location

Loc Qty

Loc Code

GA

70

32896

2

76188

3

78950

24

79688

41

140

f

51.2274

1.395

14.68421

M6061T6B0.500X05.00

Purchased

No

0

M6061T6B0 500X05 000

6061-T6 Bar .500 x 5.00

**

Location

Loc Qty

Loc Code

MAT001

21.834

112154

6.935

117933

2.123

119346

12.776

MAT004

29.3934

120243

24

120421

5.3934

M120866

X12

2.8

of 12/03/09

Picklist Print

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Work Order ID: 80259

Parent Item: D3560-041

Parent Item Name: Arm Weldment

80259

D3560-041

Start Date: 15/02/2012

Required Date: 29/02/2012

Start Qty: 10.00

Required Qty: 10.00

D3592-1

Manufactured No

190

Each

27.0000

1

10

**

12.04.30

D3592-1

Plate

Location

Loc Qty

Loc Code

WA

B20319

4

78934

4

WA002

23

47015

2

78934

21

1

DART AEROSPACE LTD		Work Order:	
Description: Arm		Part Number:	D3560-1
Inspection Dwg: D3560	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

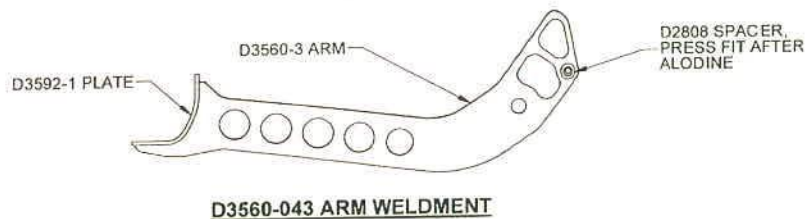
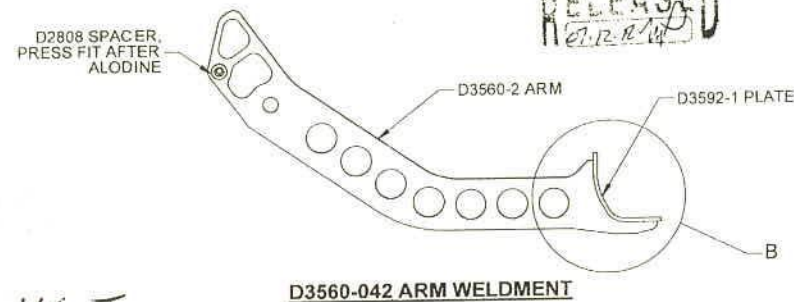
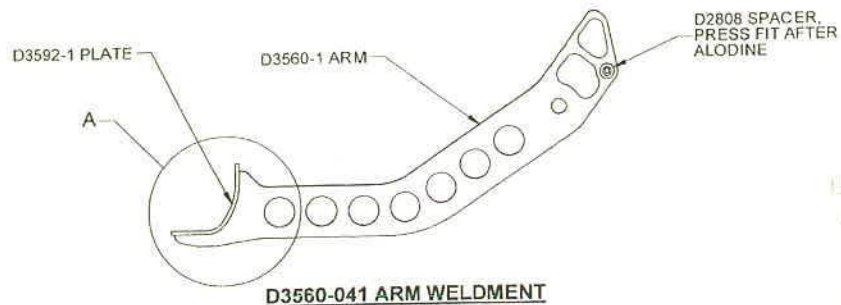
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.507	+0.000/-0.001	.5070	-			
Ø0.196	+0.005/-0.001	.196	-			
Ø1.000	+0.010/-0.001	1.004	✓			
0.500	+/-0.010	.496	-			
0.250	+/-0.010	.249	-			
0.275	+/-0.010	.274	-			
0.188	+/-0.010	.190	-			
2.000	+/-0.010	2.000	-			
1.700	+/-0.010	1.700	-			
Ø0.385 x 100°	+/-0.010 x 0.5°	.385 x 100°	-			
0.250 Deep	+/-0.010	.252	-			

Measured by: <i>DR</i>	Audited by: <i>BA</i>	Prototype Approval:	N/A
Date: 12-3-15	Date: 12/03/16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue P/O D3560-041	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM	
C	08.07.24	Dwg Rev updated	KJ/DD <i>AD</i>	<i>DD</i>

RELEASED
07.12.2016



80259 M.C.J
12/02/16

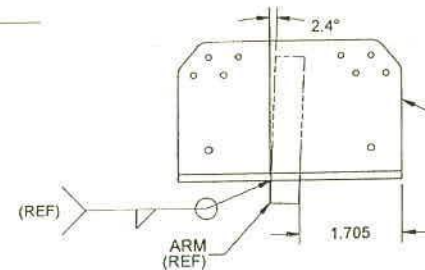
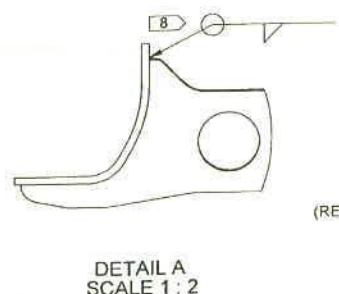
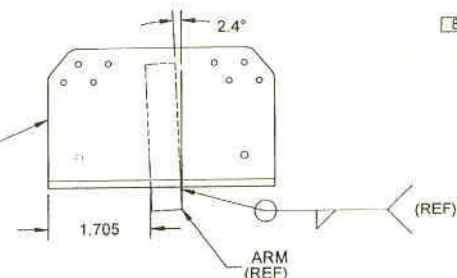


PLATE (REF)



PARTS LIST

QTY -041	QTY -042	QTY -043	QTY -044	P/N	DESCRIPTION
X				D3560-041	ARM WELDMENT
	X			D3560-042	ARM WELDMENT
		X		D3560-043	ARM WELDMENT
			X	D3560-044	ARM WELDMENT
1	1	1	1	D2808	SPACER
1				D3560-1	ARM
	1			D3560-2	ARM
		1		D3560-3	ARM
			1	D3560-4	ARM
1	1	1	1	D3592-1	PLATE

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.23 lbs (TYP)
 - 8) WELDING: PER DART QSI 004

D	ADD D2808 PRESS FIT NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
C	REMOVE POWDER COAT	CP	07.06.19
B	REDESIGN AS WELDMENT, ADD POCKETS	CP	07.01.15
A	NEW ISSUE	CP	06.09.25
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.11.16		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

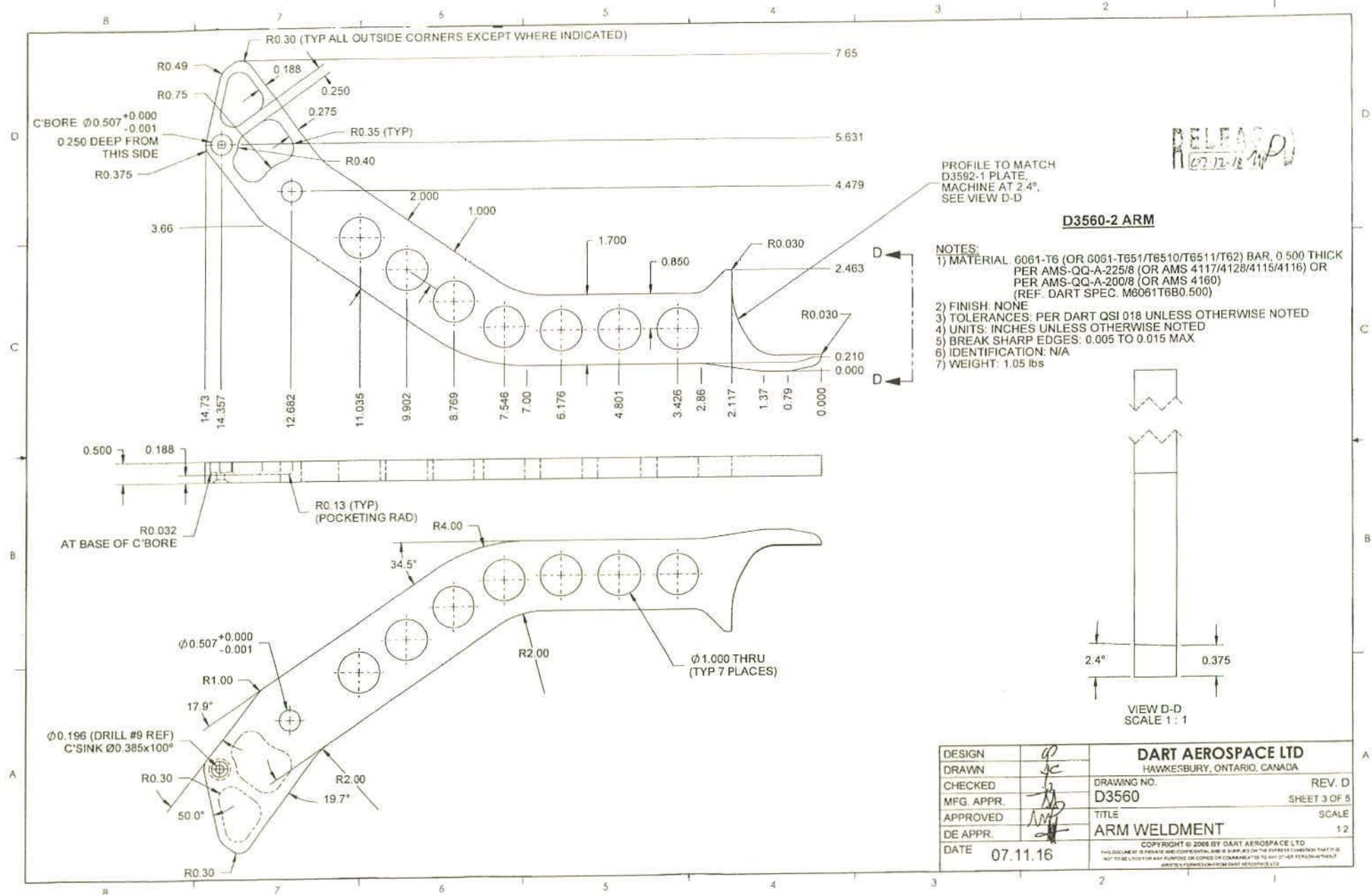
DRAWING NO. **D3560** REV. D
SHEET 1 OF 5

TITLE **ARM WELDMENT** SCALE 1:4

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DESIGN	90	DART AEROSPACE LTD	
DRAWN	JK	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO	REV. D
MFG. APPR.	JS	D3560	SHEET 2 OF 5
APPROVED	JS	TITLE	SCALE
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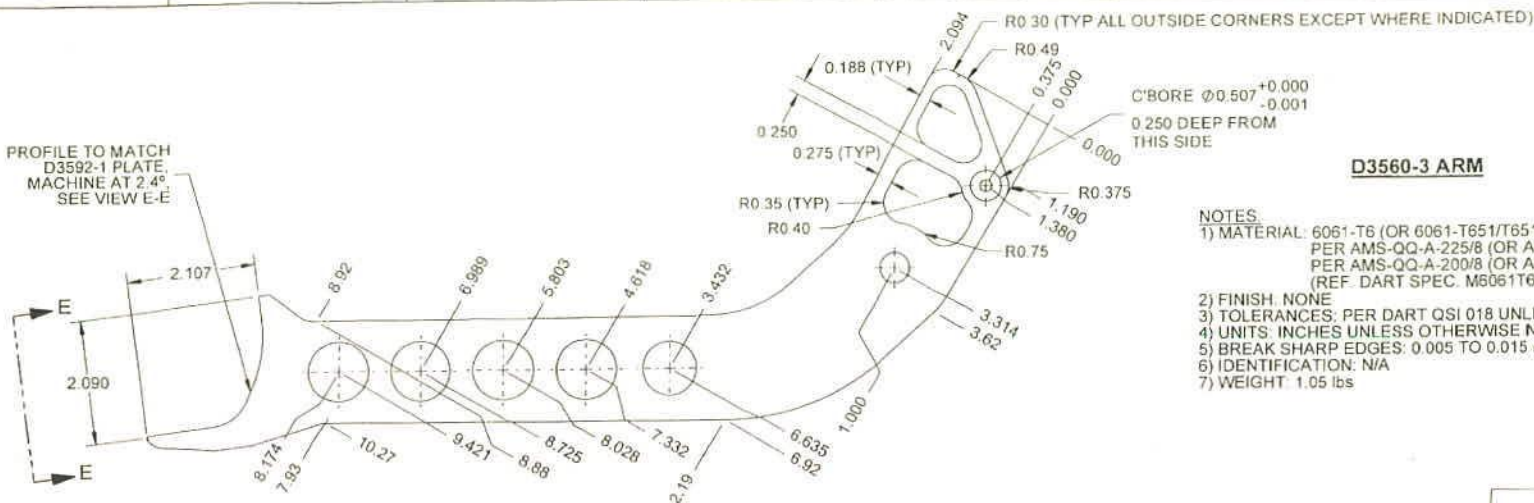
80259



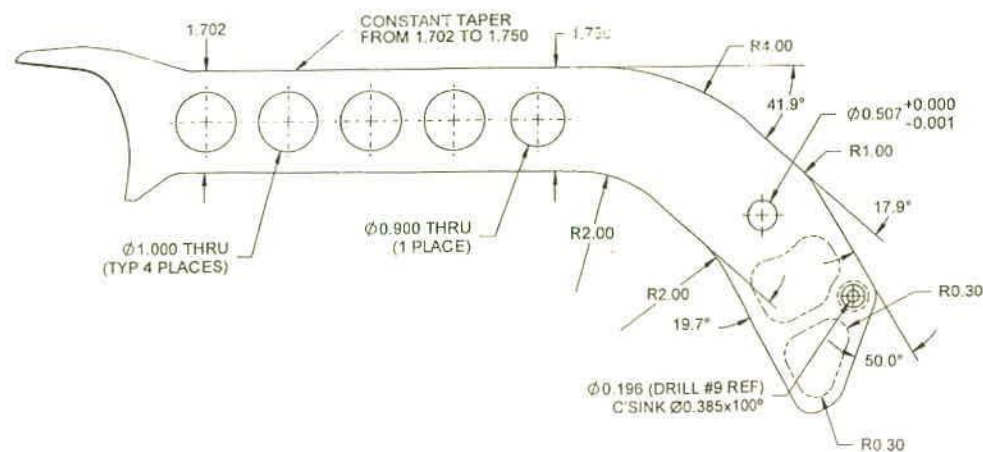
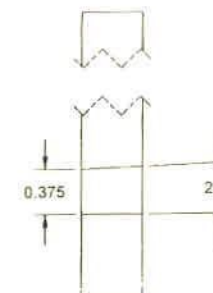
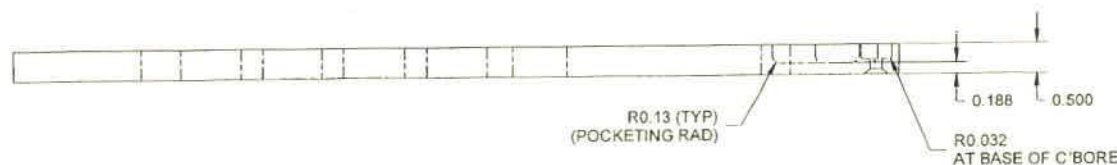
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80259

PROFILE TO MATCH
D3592-1 PLATE
MACHINE AT 2.4°
SEE VIEW E-E

**D3560-3 ARM****NOTES**

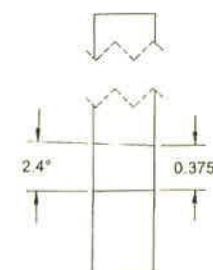
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T680.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs



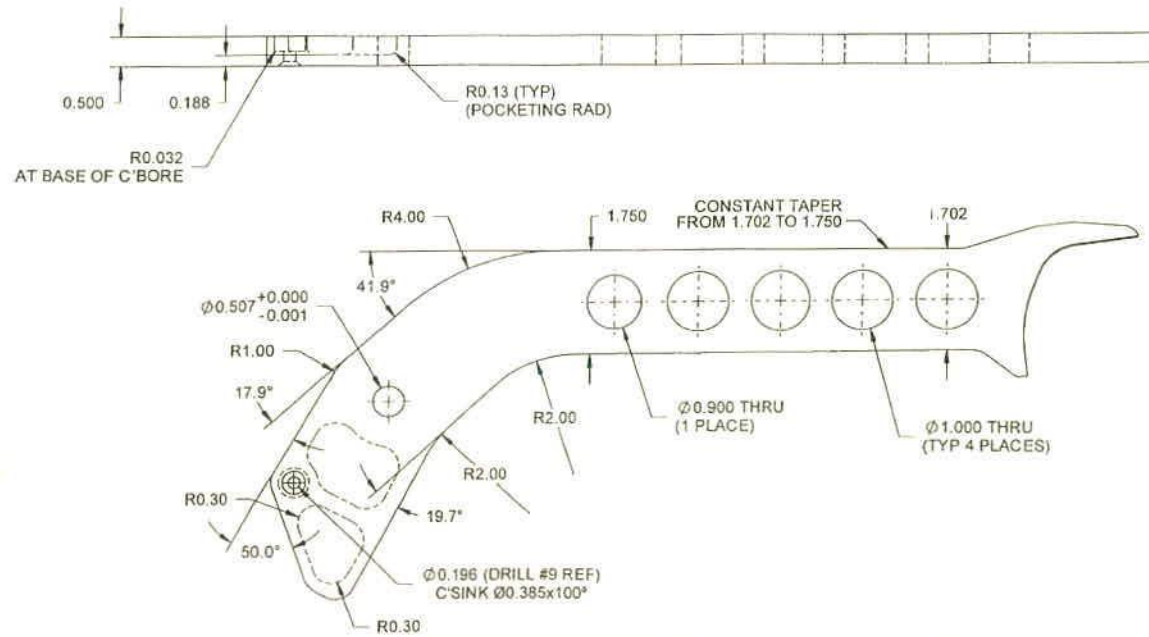
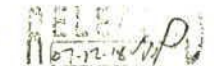
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CHECKED	A	DRAWING NO.	REV
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D3560-4 ARM

- NOTES:**
 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 (REF. DART SPEC. M6061T6B0.500)
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 1.05 lbs



VIEW F-F
SCALE 1 : 1



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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG APPR.		D3560	SHEET 5 OF 5
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